

Work Order ID 145245

Thursday, May 05, 2016 9:21:15 AM

145245

Page 1

Item ID: D2011-101

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mirror 6"

Start Date: 5/6/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAY 05 2016

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2011	Rev G

100 PURCHASING 0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 32306 Mirror P/N: 28663 supplier: B C
INDUSTRIAL Material release note required12 MAY 09 2016DAS
13
9-89

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo

0.24

Packaging

Ensure material certification is attached

12x SP/6-05-19

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo

0.00

Quality Control

(12)DAS
38
9-89
MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mirror 6"

Start Date: 5/6/2016 Start Qty: 12.00

12

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Required Date: 5/20/2016 Req'd Qty: 12.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.48							
Small Fab	1- Wrap mirror with plastic wrap								
	2- Discard Hardware & Install new hardware loosely								
	3- Crimp stud as per Dwg D2011								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.24							
Quality Control	4- Test assembly to 50lbs pull test after 24 hours								
150	Identify as per dwg & Stock Location: <u>51366</u>	0.00							
150									
Packaging	Memo	0.12							
Packaging									

12X 16/06/08 36 9-89

12 DAS 38 9-89 JUN 11 2016

12 DAS 6 9-89 JUN 13 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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				OTHER : ☐					

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Page 3

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Revision ID: Stop ***NS2***
Item Name: Mirror 6"
Start Date: 5/6/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/20/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	1.20							
Quality Control									

MCS JUN 13 2016

MCS JUN 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, May 05, 2016 9:21:19 AM

Page 1

Work Order ID: 145245

145245

Parent Item: D2011-101

D2011-101

Parent Item Name: Mirror 6"

Start Date: 5/6/2016

Required Date: 5/20/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: J04.09.15 Added Steps 5-7 KJ/JLM IPP:
K05.12.15 chg black sikaflex for white EC IPP L 08.11.06 new
drawing EC verify: DD IPP: M 08.12.19 Added step 3 KJ Verified
by: LL IPP rev N 10.01.13 added wrap per ncr09-118 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0416J		Purchased	No			110	Each	4,234.000	1	12			DAS 36 9-89
NAS1149D0416.1									**			16/06/08	
WASHER													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				222					
				m131511				222		12			
				ST260a				1984					
				m131511				1984					
				ST264				2028					
				m131511				2028					
CHM-10601		Purchased	No			130	Each	0.0000	1	12			
CHM-10601									**			12x SP/6-05-07	
Mirror 6"													
D2829		Manufactured	No			130	Each	45.0000	1	12			DAS 36 9-89
D2829									**			16/06/08	
Threaded Stud													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				45					
				122346				45		12			
D3014-1		Manufactured	No			130	Each	170.0000	1	12			DAS 36 9-89
D3014-1									**			16/06/08	
Lock Nut													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST015				170					
				122272				170		12			

DQA: _____ Date: _____

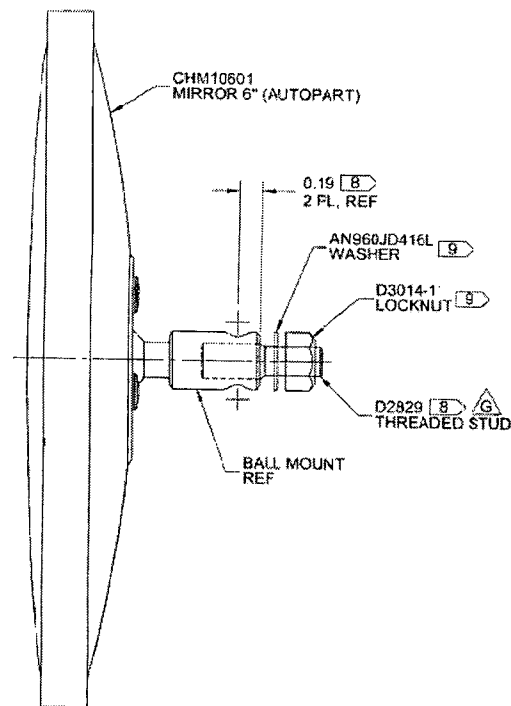


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

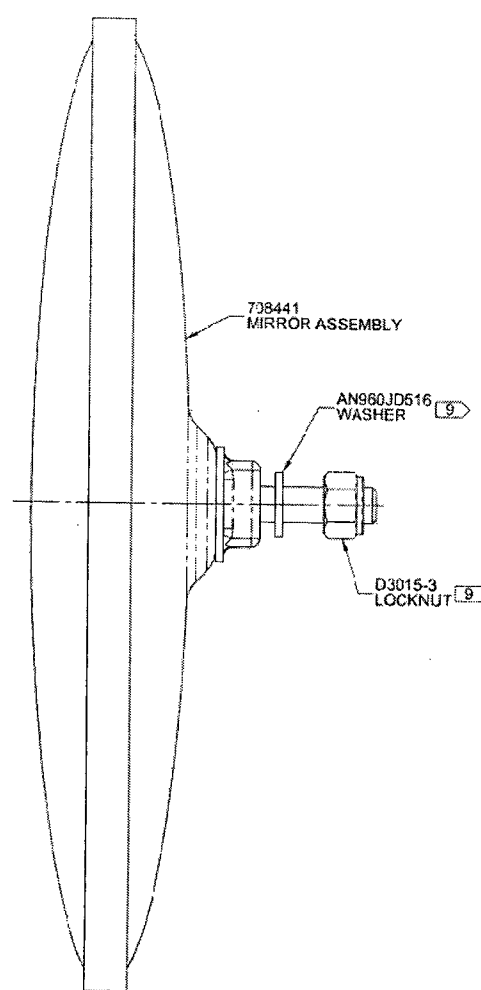
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Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								



D2011-101 MIRROR ASSEMBLY 6"

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2011-101 = 0.6 lbs APPROX. ; D2011-103 = 1.0 lbs APPROX.
- 8) D2829 INSTALLATION PROCEDURE:
 - APPLY LOCKTITE 262 TO $\phi 5/16$ END OF D2829
 - THREAD BY HAND INTO BALL MOUNT UNTIL ENTIRE $\phi 5/16$ END OF D2829 IS WITHIN BALL MOUNT
 - CRIMP BALL MOUNT ON TWO OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.040 ± 0.010 USING R0.125
- 9) INSTALL LOOSE



D2011-103 MIRROR ASSEMBLY 8"

ITEM	QTY -101	QTY -103	P/N	DESCRIPTION
1	X		D2011-101	MIRROR ASSEMBLY 6"
2		X	D2011-103	MIRROR ASSEMBLY 8"
3	1		D2829	THREADED STUD
4	1		D3014-1	LOCKNUT
5		1	D3015-3	LOCKNUT
6	1		CHM10601	MIRROR 6" (AUTOPART)
7		1	708441	MIRROR 8" (VELVAC)
8	1		AN960JD416L	WASHER
9		1	AN960JD516	WASHER

STOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 145245 MJS
16-05-05

RELEASED
08-10-29/11

G	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. MIRROR 6" (AUTOPART) AND CHM10601 WERE MIRROR 6" (GROTE) AND P/N 28043 (ZN D3-1). ADDED D2829 (ZN D3-1 AND ZN C8-1). REMOVED DRILLING NOTE, VIEW A-A AND SIKAFLEX APPLICATION NOTE. REASON: GROTE PRODUCT IS DISCONTINUED	MB	08-10-06
F	ADD HOLES FOR SEALANT ON -101	CP	04.09.10
E	NEW 8" MIRROR	CP	01.05.08
D	NEW 6" MIRROR, ADD NUT, REMOVED STUD	CP	01.04.23
C	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS. ADDED STUDS, REDRAWN	RF	99.06.01
B	SIKAFLEX 241 ADDED	JB	98.04.09
A	DWG NO. WAS DSP1011. ADDED -103	JB	90.06.15
-	NEW ISSUE	JB	90.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JB		
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR	JB	D2011	SHEET 1 OF 1
APPROVED	JB	TITLE	SCALE
DE APPR	JB	MIRROR ASSEMBLY	NTS
DATE	08.10.06	COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DRAWING IS A TRADE SECRET AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32306

Purchase Order Date 5/9/2016 10:29:06 AM
PO Print Date 5/9/2016

Page Number 1 of 1

Order From :

VC-BC1001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

B C INDUSTRIAL
14 OLD FOREST
KIRKLAND, QUEBEC H9J 2Z8

E-MAILED

Contact Name

Vendor Phone 514-585-8907

Ship To Contact

Ship To Phone

Ship Via: FedEx Economy collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

MAY 09 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
2	28663	Mirror 6"	5/16/2016 Yes 5/16/2016	FN	12.00 Each	\$18.70	\$224.40

AS PER DWG D2011 REV. G
B145245

Line Total: \$224.40

3	71401-45	PROCUREMENT QUALITY CLAUSES	5/16/2016 No 5/16/2016		1.00	\$0.00	\$0.00
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Procurement Quality Clauses
A005 RIGHT OF ENTRY
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

PO Total: \$224.40

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/9/2016

BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpc1@videotron.ca

FACTURE/INVOICE

INV160517DA

May 17 2016

Ref Notre PS# PS160517DA

Votre PO# 32306

Vendu a Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ont
K6A 1K7

Description	Quan.	Prix	Total
1. Grote mirror # 28663 ✓	12 ✓	18.70ea ✓	224.40
2.			
3.			
4.			
5.			

2016-05-19

224.40

HST: 29.17

253.57

#TPS/GST-142640622
#TVQ/PST-1021696907

Terms 2%10 Net 30

DATE May 17 2016

Packing Slip

PS160517DA

Livrer a/Ship to:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, Ont
K6A 1K7

PO 32306

	Description		Livrer/ship	B/O
1.	Mirror 6" # 28663	✓	12 ✓	0
2.				
3.				
4.				
5.				
6.				
7.				

Sp/6-05-19.

BC Industrial..14 Old Forest..Kirkland..Quebec..H9J-2Z8
Phone 514-585-8907 bcpcl@videotron.ca

BC Industrial..... 14 Old Forest....Kirkland....Quebec....H9J-2Z8....Canada
Phone 514-585-8907 Email bcpc1@videotron.ca

Certificate of Compliance

May 17 2016

Dart Aerospace
1270 Aberdeen
Hawkesbury, Quebec
K6A-1K7

ATT: Chantal Lavoie

This is to confirm that the parts delivered on our PS 160517DA

Grote Mirror # 28663

conforms to the specifications outlined on your purchase
order 32306

Thank you



Bryan Cameron

#TPS/GST-142640622
#TVQ/PST-1021696907

Terms 2%10 Net 30